

# Work Order ID 132282

May-05-15 3:07:26 PM

**\*132282\***

Page 1

Item ID: D3552-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Door Prop  
 Start Date: 5/05/15 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/12/15 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MLS Date: MAY 05 2015 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                     | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                |
|--------------------------------|----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                          |                      |         |        |              |               |               |                  |                               |
| D3552                          | K                                            |                      |         |        |              |               |               |                  |                               |
| 100                            | PURCHASING                                   | 0.00                 |         |        |              |               |               |                  | MAR 05 2015                   |
| <b>*100*</b>                   |                                              |                      |         |        |              |               |               |                  |                               |
| Purchasing                     | Memo                                         | 0.00                 |         |        |              |               |               |                  | <u>02</u> <u>10</u>           |
| Purchasing                     | Issue P/O: <u>28377</u>                      |                      |         |        |              |               |               |                  |                               |
|                                | Purchase Part Number: B8-220-530-070N        |                      |         |        |              |               |               |                  |                               |
|                                | Supplier: LS Technologies                    |                      |         |        |              |               |               |                  |                               |
|                                | Certificate of conformity is required        |                      |         |        |              |               |               |                  |                               |
| 110                            | Receive & Inspect for Damage & Mat'l Certs   | 0.00                 |         |        |              |               |               |                  |                               |
| <b>*110*</b>                   |                                              |                      |         |        |              |               |               |                  |                               |
| Packaging                      | Memo                                         | 0.00                 |         |        |              |               |               |                  | <u>10x</u> <u>SP 15-05-12</u> |
| Packaging                      | Ensure certificate of conformity is attached |                      |         |        |              |               |               |                  |                               |
| 120                            | QC6- Inspect dimensions to drawing           | 0.00                 |         |        |              |               |               |                  |                               |
| <b>*120*</b>                   |                                              |                      |         |        |              |               |               |                  |                               |
| QC                             | Memo                                         | 0.00                 |         |        |              |               |               |                  | <u>10</u> <u>MAY 13 2015</u>  |
| Quality Control                | Test for correct pressure                    |                      |         |        |              |               |               |                  |                               |

May-05-15 3:07:26 PM

**Item ID:** D3552-7

**Accept**

**\*N900040100\***

**Setup Start \*NS1\***

Revision ID:

**Item Name:** Door Prop

Stop \*NS2\*

**Start Date:** 5/05/15      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 5/12/15      **Req'd Qty:** 10.00

**\*10\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop** **\*NR2\***

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

130

Identify as per dwg & Stock Locations:

0.00

**\*130\***

## Packaging

## Memò

0.00

## Packaging

10  
DAS  
27  
9-5

MAY 13 2015

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

MLJ MAY 15 2015

MLS MAY 14 2015

# Picklist Print

May-05-15 3:07:26 PM

Page 1

Work Order ID: 132282

**\*132282\***

Parent Item: D3552-7

**\*D3552-7\***

Parent Item Name: Door Prop

Start Date: 5/05/15

Required Date: 5/12/15

Start Qty: 10.00

Required Qty: 10.00

**Comments:**

IPP Rev:A New Issue 06-11-13 EC  
04-20 rev.d as per dwg DD verified by:EC  
DD 10.02.17 verified by:EC  
DD verf:EC  
IPP Rev:B 09-  
IPP Rev:C as per dwg RevE  
IPP Rev:D 10.12.03 as per dwg rev.G

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

B8-220-530-070N

Purchased

No

110

Each

0.0000

1

10

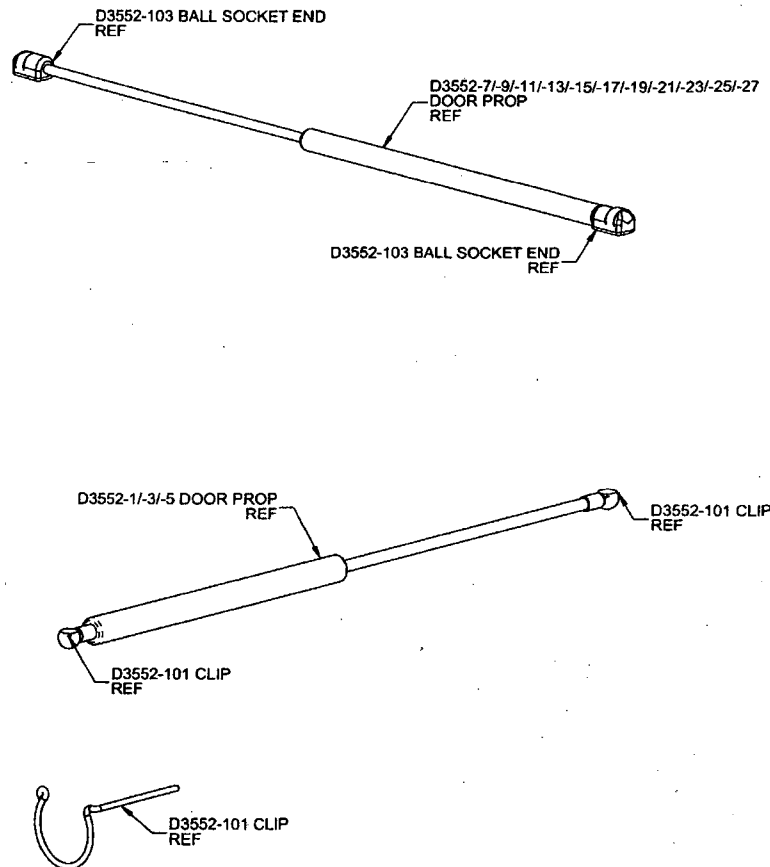
**\*B8-220-530-070N\***

CARBON STEEL GAS SPRING

\*\*

10X SP 5-05-12

# SPECIFICATION CONTROL DRAWING



132282 MJS

MAY 05 2015  
RELEASED  
2012-07-24

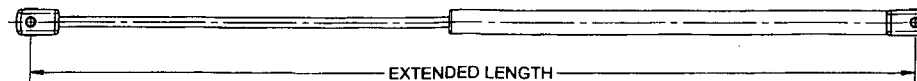
|            |                                                                                                                                                                                                                 |     |          |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|----------|
| K          | ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PART 200.                                                                                                    | MB  | 12.07.16 |
| J          | ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/8.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2.                 | AP  | 11.12.07 |
| I          | ADD P/N D3552-23                                                                                                                                                                                                | RF  | 11.10.11 |
| H          | ADD P/N D3552-21                                                                                                                                                                                                | DC  | 11.03.10 |
| G          | FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-158N | JPH | 10.11.01 |
| F          | ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER                                                                                                                                                                 | JPH | 10.07.27 |
| E          | ADD P/N D3552-13 ZN B8-1, A8-1, D8-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG                                                                                                              | HS  | 10.02.03 |
| D          | ADD P/N D3552-101 ZN D8-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1                                                              | HS  | 09.04.02 |
| C          | ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7                                                                                                                                             | LE  | 07.06.01 |
| B          | ADD D3552-7/-8; UPDATE DESC. D3552-1/-3/-5                                                                                                                                                                      | LE  | 06.10.24 |
| A          | NEW ISSUE                                                                                                                                                                                                       | LE  | 06.09.15 |
| REV.       | DESCRIPTION                                                                                                                                                                                                     | BY  | DATE     |
| DESIGN     | JE                                                                                                                                                                                                              |     |          |
| DRAWN      | JE                                                                                                                                                                                                              |     |          |
| CHECKED    | JE                                                                                                                                                                                                              |     |          |
| MFG. APPR. | JE                                                                                                                                                                                                              |     |          |
| APPROVED   | JE                                                                                                                                                                                                              |     |          |
| DE APPR.   | JE                                                                                                                                                                                                              |     |          |
| DATE       | 12.07.16                                                                                                                                                                                                        |     |          |

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3552  
REV. K  
SHEET 1 OF 2  
TITLE DOOR PROP  
SCALE NTS

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| DART PART NUMBER | DESCRIPTION               | STROKE (mm/in) | EXTENDED LENGTH (mm/in) | FORCE (N/lb) | END FITTING            | MATERIAL     | SUPPLIER        | SUPPLIER PART NUMBER OR MODEL NUMBER |
|------------------|---------------------------|----------------|-------------------------|--------------|------------------------|--------------|-----------------|--------------------------------------|
| D3552-1          | DOOR PROP                 | 220/8.66       | 530/20.6                | 70/15.7      | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-220-530-070N                      |
| D3552-3          | DOOR PROP                 | 200/7.87       | 490/19.3                | 200/45.0     | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-200-490-200N                      |
| D3552-5          | DOOR PROP                 | 175/6.89       | 430/16.9                | 150/33.7     | 10mm SS BALL SOCKET    | CARBON STEEL | LS TECHNOLOGIES | C8-175-430-150N                      |
| D3552-7          | DOOR PROP                 | 220/8.66       | 530/20.9                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-220-530-070N                      |
| D3552-9          | DOOR PROP                 | 200/7.87       | 490/19.3                | 200/45.0     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-200-490-200N                      |
| D3552-11         | DOOR PROP                 | 240/9.45       | 575/22.6                | 150/33.7     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-240-575-150N                      |
| D3552-13         | DOOR PROP                 | 220/8.66       | 530/20.9                | 140/31.5     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-220-530-140N                      |
| D3552-15         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 300/67.4     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-300NX                     |
| D3552-17         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 156/35.1     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-156NX                     |
| D3552-19         | DOOR PROP W/EXTRA DAMPING | 154/6.06       | 387/15.2                | 60/13.5      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-154-387-060NX                     |
| D3552-21         | DOOR PROP                 | 167/6.57       | 410/16.1                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-167-410-070N                      |
| D3552-23         | DOOR PROP                 | 190/7.48       | 475/18.7                | 70/15.7      | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B6-190-475-070N                      |
| D3552-25         | DOOR PROP W/EXTRA DAMPING | 148/5.83       | 475/18.7                | 300/67.4     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-148-475-300NX                     |
| D3552-27         | DOOR PROP W/EXTRA DAMPING | 148/5.83       | 475/18.7                | 156/35.1     | 10mm NYLON BALL SOCKET | CARBON STEEL | LS TECHNOLOGIES | B8-148-475-156NX                     |
| 2 D3552-101      | CLIP                      | N/A            | N/A                     | N/A          | N/A                    | CARBON STEEL | LS TECHNOLOGIES | C9                                   |
| 3 D3552-103      | BALL SOCKET END           | N/A            | N/A                     | N/A          | N/A                    | NYLON        | LS TECHNOLOGIES | B10                                  |

# **D3552-X DOOR PROP**

**RELEASED**  
2012-07-24

## **NOTES:**

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27 DOOR PROPS

|                                                                                                                                                                                                                                    |                                                                                       |                                        |              |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                             |  | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                              |  | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                            |  | DRAWING NO.                            | REV. K       |
| MFG. APPR.                                                                                                                                                                                                                         |  | D3552                                  | SHEET 2 OF 2 |
| APPROVED                                                                                                                                                                                                                           |  | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                           |  | DOOR PROP                              | NTS          |
| DATE                                                                                                                                                                                                                               | 12.07.16                                                                              | COPYRIGHT © 2006 BY DART AEROSPACE LTD |              |
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO28377

Purchase Order Date 5/5/2015

PO Print Date 5/5/2015

Page Number 1 of 2

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.  
314 JESSOP AVE  
SASKATOON, SK S7N 1Y6  
CA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

| Line Nbr    | Reference Vendor Part Number<br>Line Comments<br>Delivery Comments | Description/<br>Mfg ID         | Req Date/<br>Taxable<br>Promise Date | CD | Req Qty/<br>Unit of<br>Measure | PO Unit Price | Extended Price |
|-------------|--------------------------------------------------------------------|--------------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1           | B8-220-530-070N<br><br>AS PER DWG D3552 REV. K<br>B132282          | CARBON STEEL GAS<br>SPRING     | 5/8/2015<br><br>Yes<br>5/8/2015      |    | 10.00 ✓<br><br>Each            | \$36.85       | \$368.50       |
| Line Total: |                                                                    |                                |                                      |    |                                |               | \$368.50       |
| 2           | 71401-45                                                           | PROCUREMENT<br>QUALITY CLAUSES | 5/8/2015<br><br>No<br>5/8/2015       |    | 1.00 ✓                         | \$0.00        | \$0.00         |
| Line Total: |                                                                    |                                |                                      |    |                                |               | \$0.00         |

PO Instructions: Fedex Acc#151793240

Note:

5/5/2015

LS Technologies Inc  
314 Jessop Ave  
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

# Packing Slip

| P.O. No. | Date      | Invoice # |
|----------|-----------|-----------|
| 28377    | 5/06/2015 | 13275     |

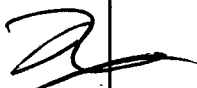
|                                                                   |
|-------------------------------------------------------------------|
| Bill to:                                                          |
| Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

|                                                                                                   |
|---------------------------------------------------------------------------------------------------|
| Ship to:                                                                                          |
| Main Finished Goods Location<br>Dart Aerospace Ltd<br>1270 Aberdeen St.<br>Hawkesbury, ON K6A 1K7 |

| Ship      | Via    | FOB |
|-----------|--------|-----|
| 5/06/2015 | Fed-Ex |     |

| Qty | Description                                                                                 |
|-----|---------------------------------------------------------------------------------------------|
| 10  | D3552-7 B132282 Gas Spring<br>Shipping Via FED EX Tracking # 773543174668<br><br>2015-05-12 |

Order checked by :





LS Technologies Inc  
314 Jessop Ave  
Saskatoon, SK, S7N 1Y6  
Ph: (306) 683-5000 Fax: (306) 683-6403

**Certificate of Compliance**

May 07, 2015

This is to certify that the parts listed below meets specifications as required by your order.

**10 Units: D3552-7 B132282 Gas Spring ( B8-220-530-070N )**

**Country of Manufacture: Canada  
Date of Manufacture : May 2015  
This product is ROHS compliant.**

Purchase Order #28377  
Invoice # 13275

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr  
Manager